

Work Order ID 76822

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76822

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Item ID: D412-698-023

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Automatic Door Opener, LH/RH

Start Date: 21/11/2011 Start Qty: 600

6

Cust Item ID:

Required Date: 05/12/2011 Req'd Qty: 600

6

Customer:

Reference:

Approvals: Process Plan: M.L.J Date: 11/11/21 Tooling:

Run Start ***NR1***

QC: Date: SPC (Y/N):

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN D412-698	Rev E								

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D412-698-023

CHG002

S-11/2/06

M.L.J 11-12-6
(5)

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

P-4/12/6
(5)

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

S-11/2/06

(75)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76822***76822***

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Item ID: D412-698-023

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Automatic Door Opener, LH/RH

Start Date: 21/11/2011 Start Qty: 6.00

6

Cust Item ID:

Required Date: 05/12/2011 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-698-023								
	Location: _____								
	PPP Rev: <u>PG-10</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

Handwritten signature and date: 11/12/11

Handwritten signature and date: 11/12/11

Handwritten signature and date: 11-12-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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76822

D412-698-023

Required Date: 05/12/2011

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-07-12 JLM
IPP rev B ecn 1207 08.07.03 EC verified by:LL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960JD516L *AN960.ID516I *	NAS1149D0516J	Purchased	No			120	Each	0.0000	2	10	114797		
Washer D3552-11 *D3552-11*		Manufactured	No			120	Each	30.0000	51	8x			
Door Prop													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST272				30					
				74984				10					
				76059				20					
D3594-043 *D3594-043*		Manufactured	No			120	Each	5.0000	1	76089	8		
Floor Doubler Assembly, LH													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST234B				5					
				71690				5					
D3594-044 *D3594-044*		Manufactured	No			120	Each	3.0000	1	71690	8		
Floor Doubler Assembly, RH													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST234B				3					
				71691				3					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 76822

76822

Parent Item: D412-698-023

D412-698-023

Parent Item Name: Automatic Door Opener, LH/RH

Start Date: 21/11/2011

Required Date: 05/12/2011

Start Qty: 6.00

Required Qty: 6.00

D3594-5

Manufactured No

120

Each

2.0000

D3594-5

Door Doubler

**

76098 3p

Location

Loc Qty

Loc Code

ST234A

2

71692

2

120

Each

8.0000

D3622-1

Manufactured No

D3622-1

Ball Stud

**

76099 8p

Location

Loc Qty

Loc Code

ST070

8

74486

8

120

Each

1,595.000

MS20426AD4-4

Purchased

No

MS20426AD4-4

Rivet

**

76099 8p

Location

Loc Qty

Loc Code

ST317

1595

116188

1595

120

Each

67.0000

MS210731-5

Purchased

No

MS210731 5

nut plate

**

116188

Location

Loc Qty

Loc Code

ST302

67

117395

67

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

7.0 PARTS LIST - PILOT DOOR MODIFICATION KITS

Qty -015	Qty -023	Part Number	Description
X		D412-698-015	DOOR SUPPORT KIT
	X	D412-698-023	AUTOMATIC DOOR OPENER KIT
2		D3200-1	DOOR POST BLOCK
2		D3200-3	DOOR WEDGE
2		D3201-1	DOUBLER
1		D3201-3	ANGLE
1		D3201-4	ANGLE
	1	D3552-11	GAS SPRING
	1	D3594-5	DOOR DOUBLER
	1	D3594-043	FLOOR DOUBLER ASSEMBLY, LH
	1	D3594-044	FLOOR DOUBLER ASSEMBLY, RH
	2	D3622-1	BALL STUD
	1	MS21073L5	ANCHOR NUT
	2	MS20426AD4-4	RIVET
12		AN960JD10L	WASHER
	2	AN960JD516L	WASHER
12		MS21042L3	NUT (OR MS21042-3)
12		MS24693-S277	SCREW

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Revision: E

Date: 08.05.01